

Ship by April 19!

Work Order ID 57678

April 13, 2010 11:54:08 AM



Item ID: D2952-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid, 407

Start Date: 4/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2952

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2952-11 corner gussets as per Dwg D2952 12-Drill holes in D2952-3 as per Dwg D2952. 13- Deburr & Remove any Markings From Material 14-Weld as per Dwg D2952 as per QSI 004. Deburr as required 1A/R AL
ROD Batch: 112860

10-04-16

1 of 6 10-04-14

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10-04-16

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

5/10/04/16

10

Work Order ID 57678

April 13, 2010 11:54:09 AM

Page 2

Item ID: D2952-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid, 407

Start Date: 4/13/10 Start Qty: 1.00

Cust Item ID:

Required Date: 4/21/10 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130  HandFinish | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| Hand Finishing | Memo | 0.00 | 10-04-16 | | | 1 | 1 | | |
| 140  Large Fab | Large Fab | 0.00 | | | | | | | |
| Large Fab | Memo | 0.00 | 10-04-16 | | | 1 | 1 | | |
| Large Fab | 1-Assemble Label Plate as per Dwg D2952 | | | | | | | | |
| 150  QC | QCS- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | 5/10/04/19 | | | | | | |

Work Order ID 57678



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April 19, 2010 10:20:10 AM

| | | | | | | |
|----------------|-----------------|------------|------|-------|---------------|--|
| Item ID: | D2952-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Basket Lid, 407 | | | | | |
| Start Date: | 4/13/10 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 4/21/10 | Req'd Qty: | 1.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 160 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| | Memo FIRST COAT: <input type="checkbox"/> START TIME: 8:30am <input type="checkbox"/> OVEN TEMPERATURE: 320°F <input type="checkbox"/> FINISH TIME: 9:00am <input type="checkbox"/> 2ND COAT (IF NECESSARY): <input type="checkbox"/> START TIME: <input type="checkbox"/> OVEN TEMPERATURE: 1/6am <input type="checkbox"/> FINISH TIME: 1/12 | | | | | | | | 10/04/19 |
| 170 QC | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | 10/04/19 |
| 175 Small Fab | | 0.00 | | | | | | | |
| Small Fab | Memo assemble per drwg IIN D407-663 | 0.00 | | | | | | | 10/04/19 |

Work Order ID 57678

April 19, 2010 10:20:14 AM



Page 4

Item ID: D2952-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid, 407

Start Date: 4/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

176

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/20

(70)

8/10/10/20 - Pick Kit to ship with L.O. -
See next page for L.O. 5

SD

P.O. =>

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

8/10/10/20

QC4 inspect kit

8/10/10/20 +
no L.O.s.

PC 1/1/20 ①
+ return

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/20

AL 10-4-20
①

Dart Aerospace Ltd

W/O: 57678

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|----------|------|---|----|---------|-----|-------------------------------------|--------------------------|
| | | See Attached email For relevant part | | | | | |
| 10/01/20 | | - Need to add parts to kit to be replaced - Pick kit S- AN4-149 bolts qty x2 m 113359 S- AN5-179 qty x2 m 114324 | SP | 10-4-20 | | | S 10/21/20 |
| 11/11/19 | | S- AN9603D416 washers qty x4 m 113706 S- MS21042L4 nuts qty x4 m 114108 S- MS21042L5 qty x2 m 113537 S- AN4-229 qty x2 m 111965 S- AN970-4 qty x4 m 112997 S- AN9603D8 +4 m 114340 S- MS20600AD qty x4 m 107939 | SP | 10-4-20 | | | S 10/21/20 |

11/11/19 00463 J

Part No: D2952-041 PAR #: Fault Category: NCR: Yes No DQA: Date:

Resolution: Disposition: QA: N/C Closed: Date:

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Sylvie B / Eric D

L Lacelle

From: Peggy McDonald [peggy@darths.com]

Sent: April 19, 2010 10:42 AM

To: L Lacelle

Subject: RE: REVISED PO 6277 FOR HELICOPTER TRANSPORT CANADA - HM

Needs to be a complete lid (with handle and any other nuts and bolts to install it.
Hope this helps

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: April 19, 2010 10:39 AM

To: Peggy McDonald

Subject: FW: REVISED PO 6277 FOR HELICOPTER TRANSPORT CANADA - HM

Peggy?

From: Linda Pilon [mailto:linda@darths.com]

Sent: April 19, 2010 10:33 AM

To: L Lacelle; Nancy MacLeod; sbedford@dartaero.com; mfauteux@dartaero.com

Cc: Heather Mahon; Shirley Hay

Subject: RE: REVISED PO 6277 FOR HELICOPTER TRANSPORT CANADA - HM

All hardware including anything to install a complete lid. See Peggy if you need more info.

Thank you,

Linda

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: April 19, 2010 10:02 AM

To: Nancy MacLeod; sbedford@dartaero.com; mfauteux@dartaero.com

Cc: Heather Mahon; Shirley Hay; Linda Pilon

Subject: RE: REVISED PO 6277 FOR HELICOPTER TRANSPORT CANADA - HM

Hi all,

Just to be sure we're on the same page...the hardware required is the handle correct?

Please advise

Thx

Linda

From: Nancy MacLeod [mailto:nancy@darths.com]

Sent: April 13, 2010 3:51 PM

To: sbedford@dartaero.com; llacelle@dartaero.com; mfauteux@dartaero.com

Cc: Heather Mahon; Shirley Hay; Linda Pilon

Subject: REVISED PO 6277 FOR HELICOPTER TRANSPORT CANADA - HM

Revision is: Ship Date 4/20/2010

Please ship attached PO for Helicopter Transport Canada

4/19/10

****RUSH ORDER*** RUSH ORDER ****

***** include necessary hardware with lid - included in price *****

Note: I spoke to Jackie and she would like to have the lid shipped ground however she is not sure that Purolator can ship ground from DAS. If ground is not an option, please ship Purolator air.

Regards,

Nancy MacLeod

DART Helicopter Services, LLC

Tel: 1.613.632.3336

Tol: 1.800.556.4166

Fax: 1.613.632.3947

nancy@darths.com

www.darthelicopterservices.com

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4/19/10

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Picklist Print

April 13, 2010 11:54:07 AM

Page 1

Work Order ID: 57678

Parent Item: D2952-041

Parent Item Name: Basket Lid, 407

Comments: IPP Rev: C[103.11.26] Reformat [KJ/RFL]
IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

Start Date: 4/13/10

Required Date: 4/21/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D2953-077



Spacer

Manufactured

No

100

Each

35.0000

2.0000

Pl 10.04.13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST031

35

36032

35

D2953-175



Spacer

Manufactured

No

100

Each

25.0000

1.0000

2

Pl 10.04.13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

25

56985

7

57335

18

D2957



Mounting Plate

Manufactured

No

100

Each

13.0000

6.0000

1

Pl 10.04.13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA *857697*

13

56660

1

57088

12

1

5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 2

April 13, 2010 11:54:07 AM

Work Order ID: 57678



Parent Item: D2952-041



Parent Item Name: Basket Lid, 407

Start Date: 4/13/10

Required Date: 4/21/10

Comments: IPP Rev: C1103.11.26 L: Reformat [IKJ/RFL]
IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2983 | | Manufactured | No | | | 140 | Each | 5.0000 | 1.0000 | | | |



Lable Plate



10.04.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

32023

5

M1100H14ES-
3/4X.051F

Purchased

No

140

sf

12.0000

15.7895



10.04.16

Alum Expanded Metal

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

3114392

12

15444

12

M5052H32S.080

Purchased

No

100

sf

103.0000

0.0658



10.04.14

5052-H32 .080 Sheet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT22

103

100682

5

100742

62

100947

33

19729

3

0.0658

April 13, 2010 11:54:07 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

April 13, 2010 11:54:08 AM

Work Order ID: 57678



Parent Item: D2952-041



Parent Item Name: Basket Lid, 407

Start Date: 4/13/10

Required Date: 4/21/10

Comments: IPP Rev: C 03.11.26 Reformat KJ/RF

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6TS0.750W.06 2 | | Purchased | No | | | 100 | f | 117.1489 | 39.4737 | | | |



6061-T6 SQ Tube .75 x .75 x .062W



SAD 10-04-13

| Warehouse | Loc Qty | Loc Code |
|-----------------|----------|----------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT06 | 117.1489 | |
| 103069 | 38.0526 | |
| 104422 | 55 | |
| 16441 | 4.07 | |
| 9671 | 20.0263 | |

MS20600-AD4W2 Purchased No

100 Each 400.0000 34.0000



Rivet



10-04-16

| Warehouse | Loc Qty | Loc Code |
|-----------------|---------|----------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST321 | 400 | |
| 109059 | 16 | |
| 111359 | 84 | |
| 112794 | 200 | |
| 114348 | 100 | |

16
18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 1

April 19, 2010 10:20:42 AM

Work Order ID: 57678

Parent Item: D2952-041

Parent Item Name: Basket Lid, 407

Comments: IPP Rev: C03.11.26 Reformat KJ/RF
IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

Start Date: 4/13/10

Required Date: 4/21/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

AN3-20A



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST352

49

105125

49

Each

22.0000

2.0000

AN5-21A



Bolt

Purchased

No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST339

22

16463

22

Each

0.0000

2.0000

AN960JD516



Washer

D2530



Handle Weldment

Purchased

No

NAS1149D0563J

M113706



Manufactured

No

Each

6.0000

1.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST508

6

56058

6

2
4/5/10/04/19

2
4/5/10/04/19

2
4/5/10/04/19

1

Picklist Print

April 19, 2010 10:20:42 AM

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D2535
Spring

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST504

27

56355

27

Each

45.0000

2.0000

Manufactured No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST504

45

53181

25

57722

20

Each

1,149.000

2.0000

Purchased No

MS21042L3

Nut

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST300

1149

113537

165

113644

984

April 19, 2010 10:20:42 AM

Shop Packet Print

Picklist Print

April 19, 2010 10:20:42 AM

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

MS21042LS



Nut

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

360

113523

26

113537

134

114108

200

D2953-077



Spacer

Manufactured

No

100

Each

35.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST031

35

36032

35

D2953-175



Spacer

Manufactured

No

100

Each

25.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

25

56985

7

57335

18

April 19, 2010 10:20:42 AM

Shop Packet Print

Picklist Print

April 19, 2010 10:20:43 AM

Page 4

Work Order ID: 57678

Parent Item: D2952-041

Parent Item Name: Basket Lid, 407

Comments: IPP Rev: C 03.11.26 ☐ Reformat ☐ KJ/RF ☐
IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D2952
Mounting Plate

already on page 2

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| WA | 33 | |
| 56660 | 1 | |
| 57088 | 12 | |
| 57697 | 20 | |

M5052H32S.080

Purchased

No

100

sf

103.0000

0.0658



5052-H32 .080 Sheet

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT22 | 103 | |
| 100682 | 5 | |
| 100742 | 62 | |
| 100947 | 33 | |
| 19729 | 3 | |

April 19, 2010 10:20:43 AM

Shop Packet Print

Page 4

Picklist Print

April 19, 2010 10:20:44 AM

Work Order ID: 57678



Parent Item: D2952-041



Parent Item Name: Basket Lid, 407

Start Date: 4/13/10

Required Date: 4/21/10

Comments: IPP Rev: C 03.11.26 Reformat KJ/RF

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS20600-AD4W2 | | Purchased | No | | | 100 | Each | 400.0000 | 34.0000 | | | |



Rivet

*zberdy
on pg. 1*

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST321 | 400 | |
| 109059 | 16 | |
| 111359 | 84 | |
| 112794 | 200 | |
| 114348 | 100 | |

D2983



Lable Plate

Manufactured No

140 Each 5.0000 1.0000



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 5 | |
| 32023 | 5 | |

Picklist Print

Page 6

April 19, 2010 10:20:44 AM

Work Order ID: 57678



Parent Item: D2952-041



Parent Item Name: Basket Lid, 407

Start Date: 4/13/10

Required Date: 4/21/10

Comments: IPP Rev: C 03.11.26 Reformat KJ/RF
IPP Rev: D 08-03-18 ecn1155 DD verified by: ec

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M1100H14ES- 3/4X.051E | | Purchased | No | | | 140 | sf | 76.0000 | 15.7895 | | | |



Alum Expanded Metal



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

76

114392

64

15444

12

already on page 2

D2851-45

D2961

B 32019

B57851

1 & 12/4/19

① 5/10/17

April 19, 2010 10:20:44 AM

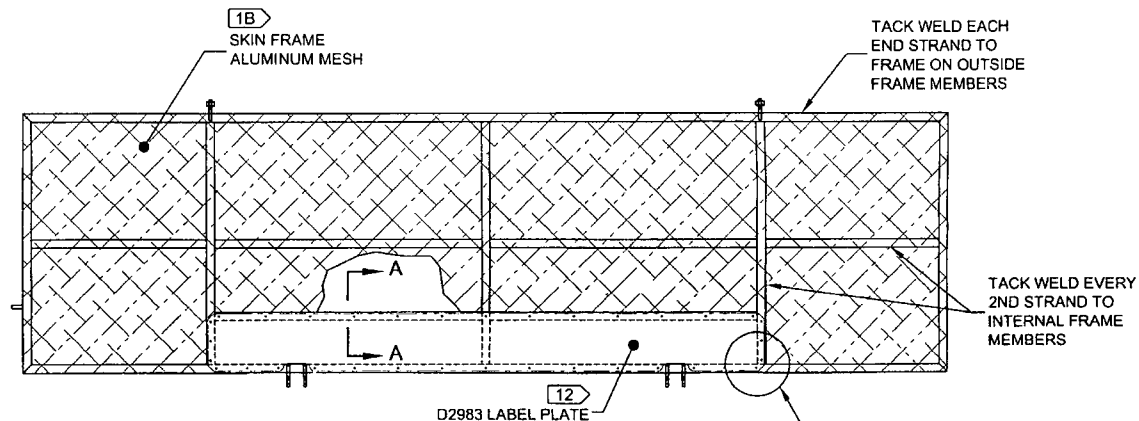
Shop Packet Print

Page 6

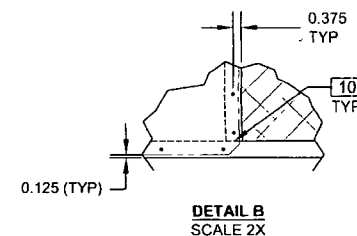
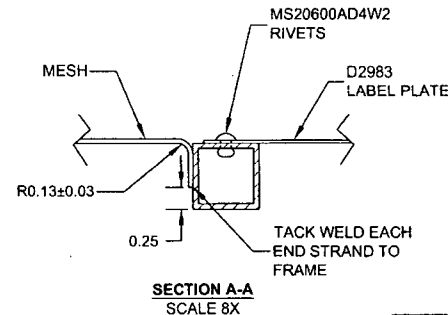
D407-663-01

D2952-041 BASKET LID ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|------|------------------|---------------------------------|
| -041 | | |
| X | D2952-041 | BASKET LID ASSEMBLY |
| 2 | D2952-1 | FRAME MEMBER |
| 2 | D2952-3 | FRAME MEMBER |
| 3 | D2952-5 | FRAME MEMBER |
| 2 | D2952-7 | FRAME MEMBER |
| 4 | D2952-9 | FRAME MEMBER |
| 4 | D2952-11 | GUSSET |
| 1 | D2953-175 | SPACER |
| 2 | D2953-077 | SPACER |
| 6 | D2957 | MOUNTING PLATE |
| 1 | D2983 | LABEL PLATE |
| A/R | M1100EX0.75-051F | 3/4 #0.051F 1100 EXPANDED METAL |
| 34 | MS20600AD4W2 | RIVET |



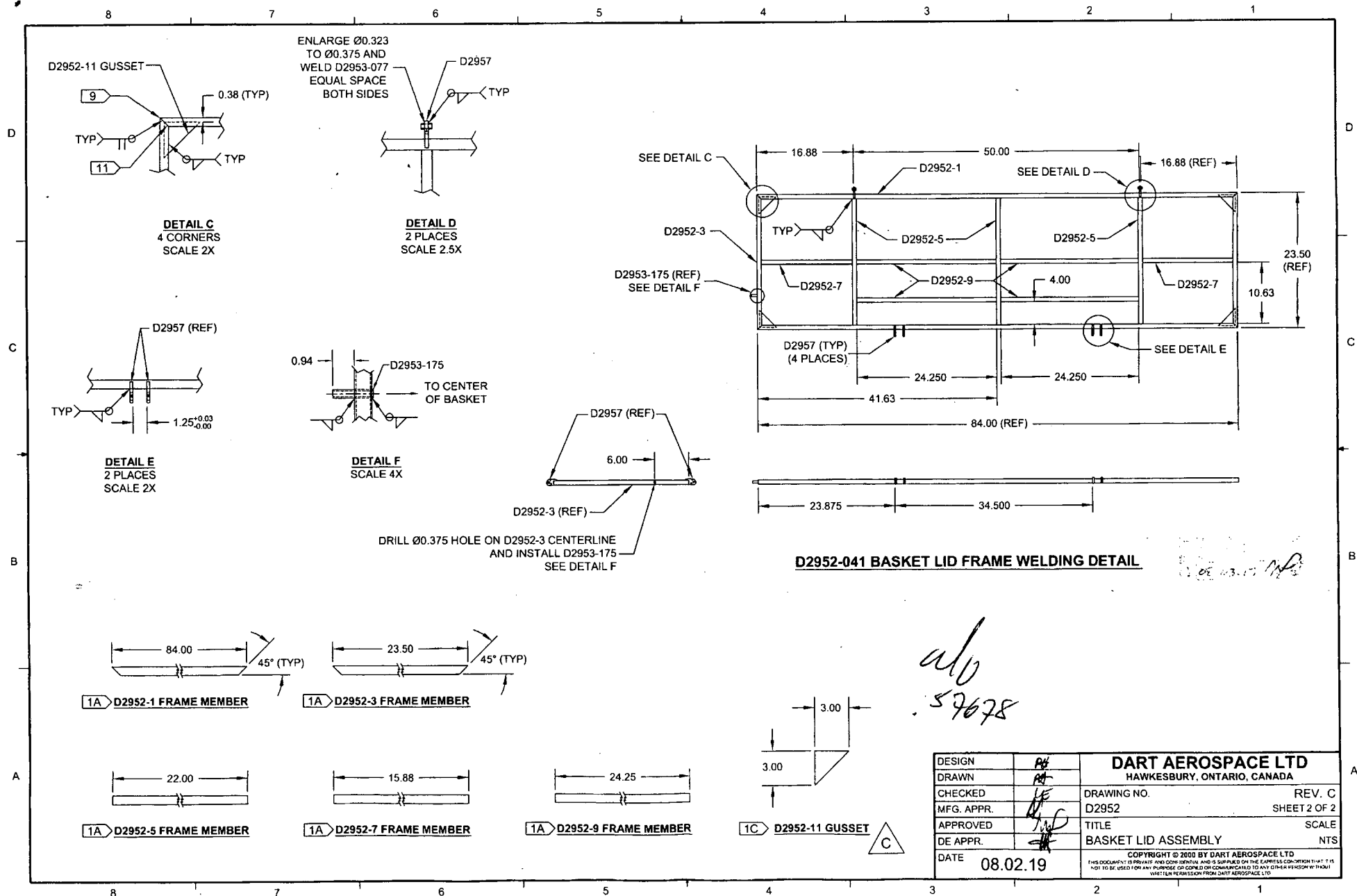
D2952-041 BASKET LID MESH AND LABEL PLATE ASSEMBLY DETAIL



NOTES:

- 1) MATERIAL: A) FRAME: 6061-T6 (OR T651/T6510/T6511/T62) 0.75 X 0.75 X 0.062 WALL SQUARE TUBING PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (AMS 4160) (REF. DART MATERIAL SPEC M6061T6TS0.750W.062)
B) MESH: 5005-H34 OR 3003-H14 OR 1100-H14/H18, 3/4 #0.051F EXPANDED METAL (FLATTENED) (REF. DART MATERIAL SPEC M1100EX0.75-051F)
C) GUSSET: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 (OR AMS 4025/4027) (REF. DART MATERIAL SPEC M6061T6S.080)
OR 5052-H32 ALUMINUM SHEET 0.080 THICK PER QQ-A-250/8 (OR AMS 4016) (REF. DART MATERIAL SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.8 lbs
- 8) WELD PER DART QSI 004
- 9) GRIND 0.063 MAX X 45° CHAMFER BEFORE WELDING CORNERS (TYP, 4 PLACES)
- 10) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE
- 11) GRIND CORNER WELDS ON BOTTOM SIDE OF BASKET FOR GUSSET (TYP, 4 PLACES)
- 12) TRANSFER D2983 LABEL PLATE HOLES USING Ø0.128 DRILL, INSTALL D2983 ONTO LID USING MS20600AD4W2 RIVETS (34 PLACES)

| | | | |
|------------|--|---|--------------|
| C | FRAME MATERIAL NOW 0.062 WALL (WAS 0.065 WALL); ADD M-DRAWING NOTES; ADD D2952-11 GUSSET DRAWING (ZONE A4-2); UPDATE DRAWING FORMAT; NOW 2 PAGES; REASON: DRAFTING ERROR | PH | 08.02.19 |
| B | CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11 | RF | 00.07.06 |
| A | NEW ISSUE | RF | 00.01.14 |
| DESIGN | PA | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PA | | |
| CHECKED | UE | DRAWING NO. | REV. C |
| MFG. APPR. | UE | D2952 | SHEET 1 OF 2 |
| APPROVED | UE | TITLE | SCALE |
| DE APPR. | UE | BASKET LID ASSEMBLY | NTS |
| DATE | 08.02.19 | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, IN WHOLE OR IN PART, WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD | |



L Lacelle

From: peggy@darths.com
Sent: April 13, 2010 10:30 AM
To: Heather Mahon
Cc: llacelle@dartaero.com
Subject: Fw: Damaged 407 lid

Heather - the po from nelson bill will be for a basket lid (d2952-041 - pls confirm part number on my files.) Po will be for \$2500 - das to dhs \$2200. A note must be added - include necessary hardware with lid - included in price - needs to be ready for pick-up no later than next friday. Thx Sent from my BlackBerry device on the Rogers Wireless Network

-----Original Message-----

From: "Bill Beckett" <bbeckett@dartaero.com>
Date: Tue, 13 Apr 2010 10:03:57
To: <peggy@darths.com>; 'L Lacelle'<llacelle@dartaero.com>
Subject: RE: Damaged 407 lid

Peggy - OK
Linda - please start a new lid immediately.
Thx,
Bill

-----Original Message-----

From: peggy@darths.com [mailto:peggy@darths.com]
Sent: April 13, 2010 9:51 AM
To: Bill Beckett
Subject: Re: Damaged 407 lid

Is there a way to start the new lid without a po? We will try get this sorted out no later than tomorrow.
Sent from my BlackBerry device on the Rogers Wireless Network

-----Original Message-----

From: "Bill Beckett" <bbeckett@dartaero.com>
Date: Tue, 13 Apr 2010 08:59:52
To: <peggy@darths.com>
Subject: RE: Damaged 407 lid

Peggy,
We have determined that the cost to cut out the old mesh, grind all the welds down, re-weld, re-paint will be more expensive than making a new lid.

Normal price to DHS for a new lid would be \$1,950, the repaired one at \$2,050.
I would be willing to discount these prices if you feel it is appropriate, by as much as \$300.
I would REALLY prefer to go with a replacement lid - it will be simpler for us.
Let me know what you want to do.

Bill

-----Original Message-----

From: peggy@darths.com [mailto:peggy@darths.com]
Sent: April 13, 2010 6:52 AM
To: Bill Beckett
Subject: Damaged 407 lid

Hi bill, I need your help with a return. Helicopter transport returned a lid due to tack weld breaking. It is only 2 yrs old and it was determined by dart that this would not be covered under warranty. We need to help this customer. Can this be repaired, re painted for the customer at a small cost?
They are here at hac and need to be operating soon. Thx Sent from my BlackBerry device on the Rogers Wireless Network

=====

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Any views expressed in this message are those of the individual sender, except where the sender specifically states them to be the views of DART Helicopter Services.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | Status | Item ID | Rev | Name | Start Date | Quantity | Per | UOM | Up | Date | Seq | rap | Qun | meid | N | EC | ID | CX | I | Sort | e | Off | s | Ty | Per | h | to | e | Date | Last | Mo | Add | Date |
|---|--------|---------------|-----|---------------------|------------|----------|-----|------|----|------|-----|-----|-----|------|---|----|----|----|---|------|---|------|---|----|-----|---|----|--------------|---------|------|----|-----|------|
| 1 | ✓ | D2728-3 | | Dart Logo label | 12/05/09 | 0.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2948-041 | | Basket Base, 407 | 12/05/09 | 1.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | AN960JD416L | | Washer | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2530 | | Handle Weldment | 12/05/09 | 1.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | D2952-041 | | Basket Lid, 407 | 12/05/09 | 1.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2535 | | Spring | 12/05/09 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 2 | ✓ | AN960JD416 | | Washer | 1/01/08 | 4.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | AN960JD516 ✓ | | Washer | 1/01/08 | 4.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 2 | ✓ | AN5-21A ✓ | | Bolt | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2931 | | Bumper | 12/05/09 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | D2537 | | Bushing | 12/05/09 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | AN960JD8 | | Washer | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | AN3-20A | | Bolt | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2332-041 | | Lid Prop Assembl... | 12/05/09 | 1.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| H | ✓ | AN5-17A | | Bolt | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | AN4-22A | | Bolt | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | MS21042L3 | | Nut | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | AN4-14A | | Bolt | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 2 | ✓ | D2851-145 | | Placard | 12/05/09 | 1.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | MS21042L5 | | Nut | 1/01/08 | 4.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 1/12/10 8... | 12/0... | | | | |
| 1 | ✓ | MS21042L4 ✓ | | Nut | 1/01/08 | 4.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2961 | | Label | 12/05/09 | 1.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | MS20600-AD4W3 | | Cherry Rivets | 1/01/08 | 2.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | AN970-4 | | Washer | 1/01/08 | 4.0000 | | Each | | 120 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | AN3-11A | | Bolt | 1/01/08 | 6.0000 | | Each | | 150 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D2984 | | Label | 12/05/09 | 1.0000 | | Each | | 150 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | D2852 | | Label | 12/05/09 | 1.0000 | | Each | | 150 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | D407-302-011 | | Outboard Bracket | 12/05/09 | 1.0000 | | Each | | 150 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| 1 | ✓ | D407-301-011 | | Center Bracket | 12/05/09 | 1.0000 | | Each | | 150 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 12/05/09... | 12/0... | | | | |
| | ✓ | MS21042L3 | | Nut | 1/01/08 | 12.0000 | | Each | | 150 | 0 | 0. | | | | | | | | 0 | 0 | M... | | | | | | 1/12/10 8... | 12/0... | | | | |

REFERENCE ONLY

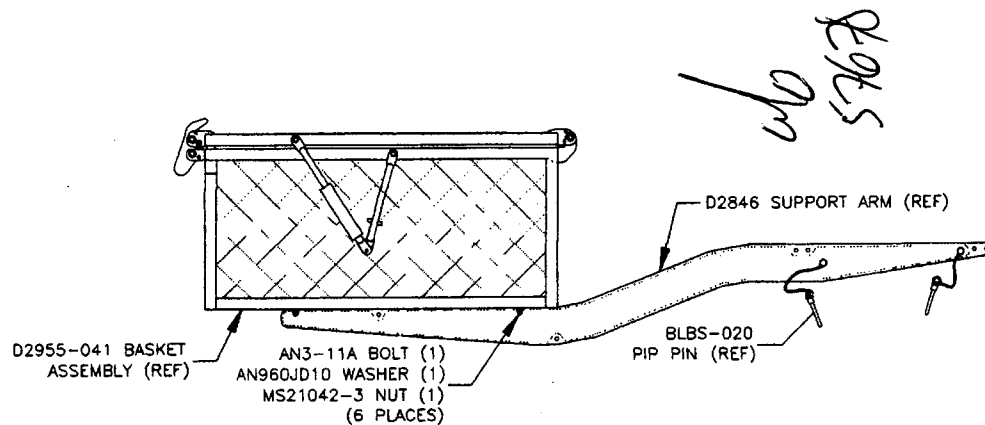


Figure 6 - Basket Mounting Detail

25.4 REPLACEMENT PARTS

Figure 7 lists components of the Dart *Heli-Utility-Basket™* which can be replaced if required. The part numbers are included for reference only, and are normally included with the D2955-041 Basket Assembly.

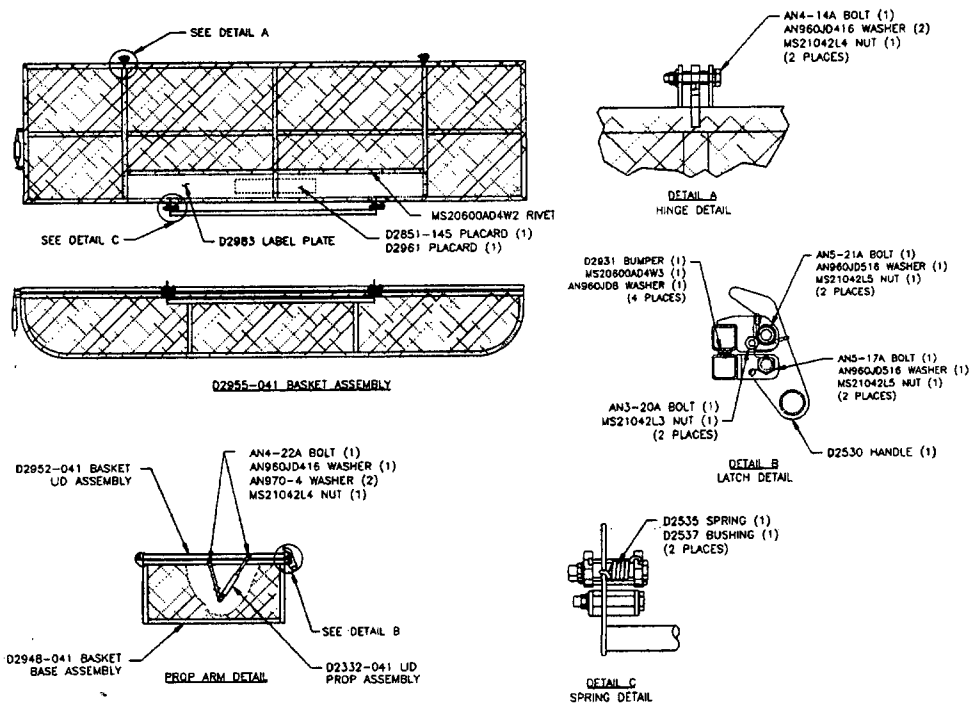


Figure 7 - Replacement Parts

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25.5 WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---|--------------------|-------------------|---------------------------|---------------------|---------------------------|
| | | Arm | Moment | Arm | Moment |
| D407-663-011 <i>Heli-Utility-Basket™</i> | 57.3 lb 26.0 kg | 41.9 in 1.06 m | 2400.9 in-lb 27.6 m-kg | 115.75 in 2.94 m | 6632.5 in-lb 76.4 m-kg |
| | | | | | |

25.6 PARTS LIST

| Qty | Part Number | Description |
|-----|---|----------------------------------|
| X | D407-663-011 | HELI-UTILITY-BASKET INSTALLATION |
| | | |
| 2 | D2012-107 | CLEVIS |
| 4 | D2022-101 | SPACERS |
| 6 | D2690-5 | LANYARD ASSEMBLY |
| 1 | D2955-041 | UTILITY BASKET ASSEMBLY |
| 2 | D2764 | CROSS BEAM |
| 1 | D2796 | MIDDLE CROSS BEAM |
| 3 | D2846 | SUPPORT ARM |
| 12 | D2847 | LUG |
| 1 | D2848 | STRUT |
| 1 | D2852 | LABEL |
| 1 | D2984 | LABEL |
| | | |
| 6 | AN3-5A | BOLT |
| 6 | AN3-11A | BOLT |
| 2 | AN4-10A | BOLT |
| 6 | AN4-13A | BOLT |
| 1 | AN4-14A | BOLT |
| 11 | AN4-17A | BOLT |
| 1 | AN4-20A | BOLT |
| 24 | AN960JD10 | WASHER |
| 21 | AN960JD416 | WASHER |
| 12 | MS21042-3 or MS21042L3 | NUT |
| 21 | MS21042-4 or MS21042L4 | NUT |
| 6 | BLBS-020 or BLRS-020 or BLC4BA15S or BLC4RA15S | PIP PIN |
| | | |

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25-00-00

D2955-041 BASKET ASSEMBLY (REF)

AN3-11A BOLT (1)

AN960JD10 WASHER (1)

MS21042-3 NUT (1)

(6 PLACES)

D2846 SUPPORT ARM (REF)

BLBS-020 PIP PIN (REF)

25.4 REPLACEMENT PARTS

Figure 7 lists components of the Dart **Heli-Utility-Basket™** which can be replaced if required. The part numbers are included for reference only, and are normally included with the D2955-041 Basket Assembly.

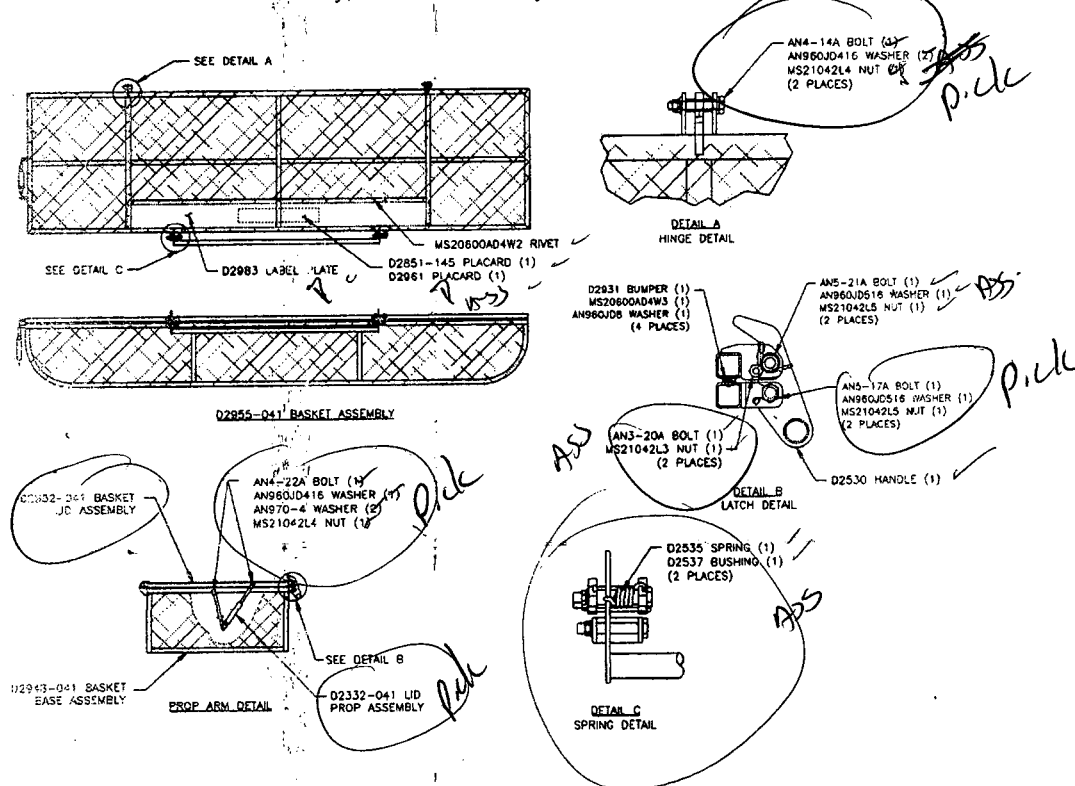


Figure 7 - Replacement Parts

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries